

Work Order ID 67207

Thursday, March 10, 2011 12:30:33 PM



Page 1

Item ID: D2563

Accept



Setup Start



Revision ID:

Item Name: Step Weldment Assembly

Stop



Start Date: 3/10/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 3/18/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:

[Signature]

Date: 11-03-11 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2563

Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2244 to 89.70" at 34 deg as per dwg D2563

2-Deburr ends

3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343

4- Grind

11-03-11

3

[Signature]

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

3 0 8E1/p3/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/10

(X3)

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

11-03-18

3

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

SB 11/03/21

(3)

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Weld per dwg A/R Aluminum rod Batch: M108436 0.00



Large Fab

Memo

0.00

Sh 11.03.21

3

Ø

Large Fab

1-Inspect for foreign object per QSI 024

2-Weld Remaining End cap as per Dwg D2563 using DT 8343

3-Grind

160

~~QC~~ Inspect visual per QSI004- Fusion Welds

0.00



QC

QC10

Memo

0.00

Sulor 121

Quality Control

P107

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Sulor 121

(x3)

Quality Control

W/O: 6207		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
n/08/01	#160	Perm. change change step to QC 10 inspection	MA	11.03.29			S w/09/21

Part No: D2563 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Stop



Start Date: 3/10/2011 **Start Qty:** 3.00

**Cust Item ID:**

Required Date: 3/18/2011 **Req'd Qty:** 3.00



Customer:

Reference:

Run Start



Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00



Memo

0.00

Touch up Alodine as per OSI005

0.00



Memo

0.00

Touch up Alodine then
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 115951

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

(Ref: 4.3.5.1) as per OSI

11-30
3200
12-00

Wing Walk as per dwg QSI005 4.4 Batch *AK116-1007*



Memo

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4/3/22 (3)

210

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

*PPP67206**4/3/24 (2)*

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*CK 11/03/25**UMF**11-03-28*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Thursday, March 10, 2011 12:30:39 PM

Page 1

Parent Item: D2563

Parent Item Name: Step Weldment Assembly

Start Date: 3/10/2011**Required Date:** 3/18/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:G 02.07.31 Re-format Location RF

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	144	
57527	1	
59690	143	

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, March 10, 2011 12:30:39 PM

Page 2

Work Order ID: 67207

Parent Item: D2563

Parent Item Name: Step Weldment Assembly

Start Date: 3/10/2011

Required Date: 3/18/2011

Start Qty: 3.00

Required Qty: 3.00

D2673-34

Manufactured No

150 Each

144.0000

1

3



End Plate



PH 11.03.11

Location

Loc Qty

Loc Code

WA

144

57527

1

~~59690~~

143

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

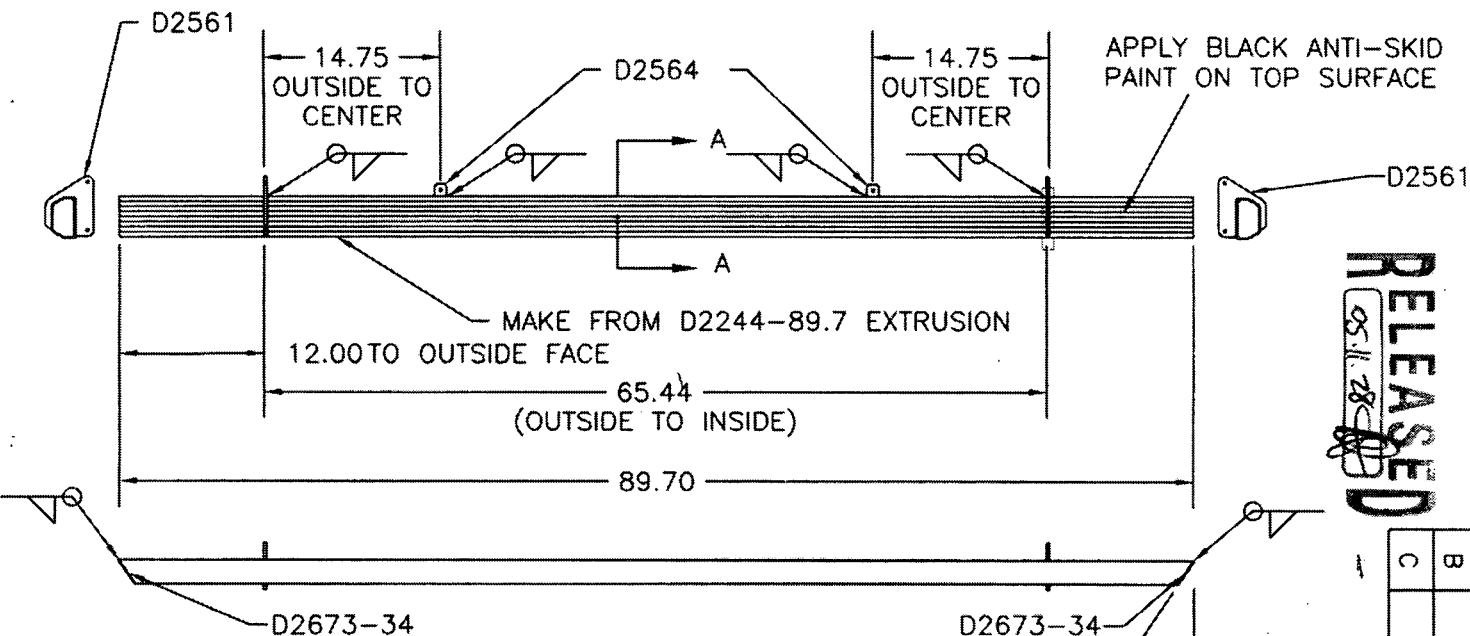
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART

RELEASED
05.11.28



D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing

D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	BW	DRAWN BY	DART AEROSPACE LTD
CHECKED		APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	05.11.14	TITLE	STEP WELDMENT ASSEMBLY
A	96.04.26	NEW ISSUE	REV. C
B	97.05.14	END CAPS CHANGED (WAS D2248)	SHEET 1 OF 1
C	05.11.14	UPDATE NOTES	SCALE 1:15

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 62207
RETURN TO
ENGINEERING
SHOP COPY

PH-08-10

W/O:		WORK ORDER CHANGES					
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